

Work Order ID 154877

Tuesday, January 03, 2017 1:08:23 PM

154877

Page 1

Item ID: D2230-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Mounting Lug
Start Date: 1/5/2017 Start Qty: 80.00 ***80*** Cust Item ID:
Required Date: 1/17/2017 Req'd Qty: 80.00 ***80*** Customer:
Reference:

Approvals: Process Plan: DAS 21 Date: JAN 03 2017 Tooling: _____ Date: _____ Run Start ***NR1***
QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2230	Rev G								
110	Outsource process - Machining	0.00							
110	HAAS CNC VERTICAL MACHINING #1								
Outsource5	Memo	4,479.82							
Outsource process - Machining	Issue P/O to Metec : <u>34837</u>								
	Machine as per dwg								
	C of C is required								
120	Receive & Inspect for Damage & Mat'l Certs	0.00							
120									
Packaging	Memo	0.27							
Packaging	Ensure C of C is attach								
130	QC6- Inspect dimensions to drawing	0.00							
130									
QC	Memo	0.27							
Quality Control									

80 JAN 05 2017 DAS 13 9-89

80x 8p17-01-19

80 DAS 38 9-89
FEB 06 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:12.5%;">Skid-tube ☐</td> <td style="width:12.5%;">Cross tube ☐</td> <td style="width:12.5%;">Water Jet ☐</td> <td style="width:12.5%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Work Order ID 154877

Tuesday, January 03, 2017 1:08:23 PM

154877

Page 2

Item ID: D2230-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Mounting Lug

Start Date: 1/5/2017 Start Qty: 80.00

80

Cust Item ID:

Required Date: 1/17/2017 Req'd Qty: 80.00

80

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

Hand Finishing

0.27

DAS
38
3-89

150

QC7-Inspect Chemical Conversion Coat

0.00

150

QC

Memo

Quality Control

0.13

DAS
38
3-89

160

White Gloss(Ref 4.3.5.1) per QSI005 4.3-Alum

0.00

160

Powdercoat

Memo

Powder Coating

0.27

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

DAS
38
3-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By	
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Root Cause		FAULT CATEGORY							
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
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Picklist Print

Tuesday, January 03, 2017 1:08:25 PM

Page 1

Work Order ID: 154877

154877

Parent Item: D2230-3

D2230-3

Parent Item Name: Mounting Lug

Start Date: 1/5/2017

Required Date: 1/17/2017

Start Qty: 80.00

Required Qty: 80.00

Comments: IPP D00.05.18Added inspection level 8, and removed P/O for powder
coatEC IPP REV :E NEW FOLIO # 10-05-
25 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2230-3P		Purchased	No				Each	0.0000		80			
D2230-3P									**				
Lug													
D2423		Manufactured	No				f	422.4855		5.751579			
D2423									**				
Lug Extrusion													

80x 8017-01-19
JAN 05 2017
DAS
13
9-89

Location

Loc Qty

Loc Code

Metec

422.4855307

127892

36.5122647

131451

97.654451

148835

288.318815

DQA: _____ Date: _____

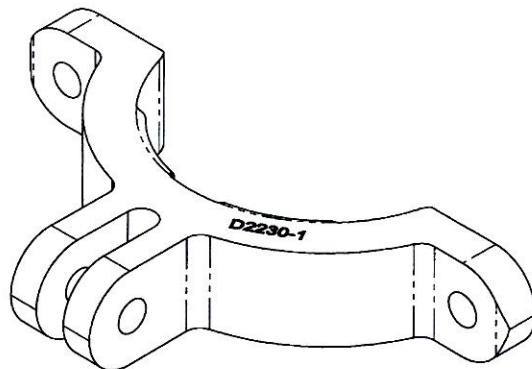


WORK ORDER NON-CONFORMANCE / UPDATE

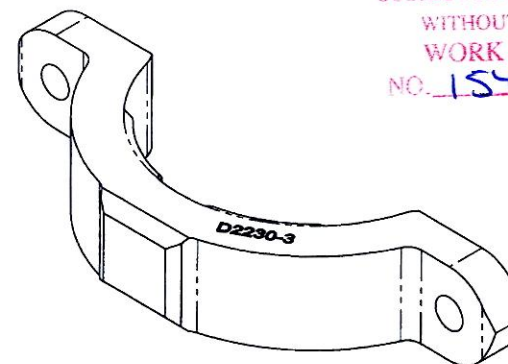
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D2230-1 MOUNTING LUG



D2230-3 MOUNTING LUG

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 154877 MJS
17-01-03

RELEASED
09/06/2015

G	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A & B-B FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION.	AJS	09.01.16
F	REDESIGN; R1.200 WAS 1.100	CP	99.12.13
E	RE-DESIGN	BW	95.01.04
D	RE-DESIGN	BW	95.01.04
C	RE-DESIGN	BW	94.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2230	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
DATE	09.01.16	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015 ± 0.005.
- 7) WEIGHT: -1: 0.16 lbs
-3: 0.14 lbs



DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. 1
MFG. APPR.		D2230	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NT
DATE	09.01.16	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED TO THE EXPRESS CONDITION THAT IT IS NOT TO BE LOANED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO34837

Purchase Order Date 1/5/2017

PO Print Date 1/6/2017

Page Number 1 of 3

Order From :

VC-MET003

METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, ON K0B 1R0
CA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED

JAN 06 2017

Contact Name

Vendor Phone 613 678 3957

Ship To Contact

Ship To Phone

Ship Via: Dart Truck

Ship Acct:

Buyer

Customer POID

Customer Tax # 10127-2607

Terms Net 10

Currency CAD

FOB Destination-Collect

Chantal Lavoie

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D2230-1P	Lug	1/18/2017 Yes 1/18/2017		50.00 Each	\$16.10	\$805.00

AS PER DWG D2230 REV. G
B154876
ALODINE AND PAINT AS PER QSI 005

Line Total: \$805.00

2 D2230-3P

Lug

DAS
38
9-89

1/18/2017 FN
Yes
1/18/2017

80.00
Each

\$13.80 \$1,104.00

AS PER DWG D2230 REV. G
B154877
ALODINE AND PAINT AS PER QSI 005

Line Total: \$1,104.00

SP17-01-19

Note:

1/6/2017



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 21516
Date: Jan 05, 2017
Page: 1

Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 34837	Sold By: VanDenYssel, David
Shipped By: your truck	Ship Date: Jan 06, 2017

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2230-1 Mounting Lug, as per drawing D2230 Rev. G Alodine and Paint as per QSI 005	Each	50 1		50 1
D2230-3 Mounting Lug, as per drawing DD230 Rev. G Alodine and Paint as per QSI 005	Each	80 1	80	1
D4091-1 Lug, as per drawing D4091 Rev.A Alodine and Paint as per QSI 005	Each	20 1	20	1
D2731-7 LUG, as per drawing D2731 Rev. C Alodine and Paint as per QSI 005	Each	24 1		24 1

The delivered goods must be inspected upon receipt to confirm compliance.
Should there be discrepancies please notify METEC within 30 days of delivery.
The goods are otherwise deemed accepted.

Received by

SP17-01-19

Thank you for your order!



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
80 ✓	D2230-3 ✓	Lug Paint Batch # 20646 Material B148835	34837
20	D4091-1	Lug Paint Batch # 20609 Material B131451	34837

Material supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Jan Norris

Vankleek Hill, January 06, 2017